












Date: Wednesday, 09/07/2008 1:13:52 PM
 User: Julie Lecocq

Process Sheet

| | |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------|-------------------------------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : WEARPLATE |
| Job Number : 40398 | |
| Estimate Number : 12901 | |
| P.O. Number : | Part Number : D350811 |
| This Issue : 09/07/2008 S.O. No. : | Drawing Number : D3508 REV C |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SMALL /MED FAB | Drawing Revision : C |
| Previous Run : 36415 | Material : |
| Written By : | Due Date : 18/07/2008 Qty: 10 Um: Each |
| Checked & Approved By : <u>JUL 08.7.09</u> | |
| Comment : Est Rev:A New Issue 07.06.12 EC Est Rev:B Rev C dwg 07-12-06 DD | |
| Additional Product | |
| Job Number:  | |
| Seq. #: | Machine Or Operation: |
| Description : | |
| 1.0 | M304S20GA 304/316 .040 Sheet |
|  | |
|  | |
| Comment: Qty.: 0.6181 sf(s)/Unit Total : 6.1814 sf(s) 304SS .038" THK (20GA) (M304S20GA) Batch: <u>108156</u> <u>HB 8-7-17</u> | |
| 2.0 | WATER JET FLOW WATER JET |
|  | |
|  | |
| Comment: FLOW WATER JET 1-Cut as per Dwg D3508 Dwg Rev: <u>C</u> <u>HB 8-7-17</u> <u>(12)</u> Prog Rev: <u>C</u> 2-Deburr if necessary <u>HB 8-7-17</u> | |
| 3.0 | QC2 INSPECT PARTS AS THEY COME OFF MACHINE |
|  | |
|  | |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>HB 8-7-17</u> | |
| 4.0 | QC8 SECOND CHECK |
|  | |
|  | |
| Comment: SECOND CHECK <u>808/7/17</u> <u>(12)</u> | |
| 5.0 | BRAKE NC NC BRAKE |
|  | |
|  | |
| Comment: NC BRAKE 1-Form on brake using DT8326 and DT8261 as per Dwg D3508 <u>SP 08/07/18</u> <u>(12)</u> | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 09/07/2008 1:13:53 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 40398

Part Number: D350811

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/18 *(412)*

7.0

POWDER COATING

POWDER COATING



M 106442



(12X)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:40
320
12:10

M 08/07/21

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FX 08/07/21 *(12)*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

FP-16

Qb/M 08/07/21

(12)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/22

Job Completion



MF 08-07-22

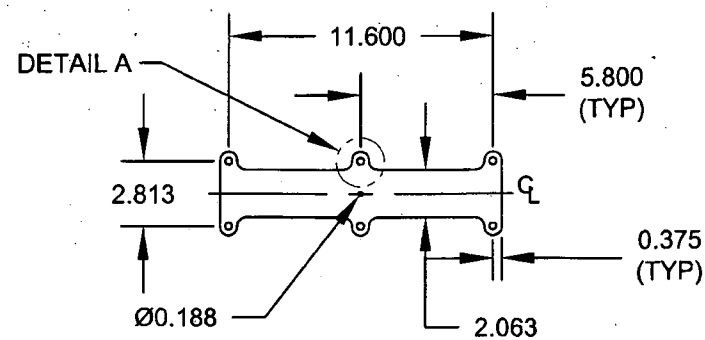
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

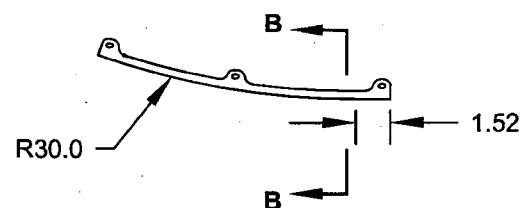
QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

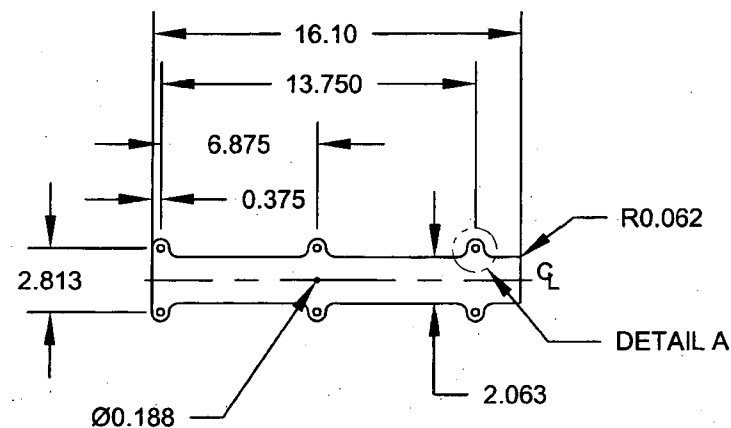
NOTE: Date & initial all entries



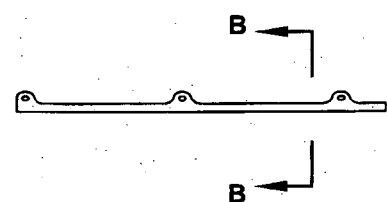
D3508-1 FLAT PATTERN



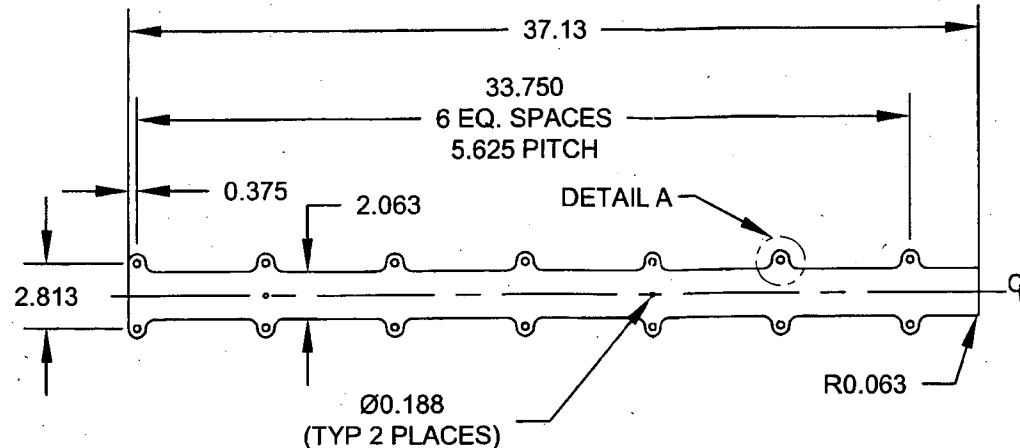
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



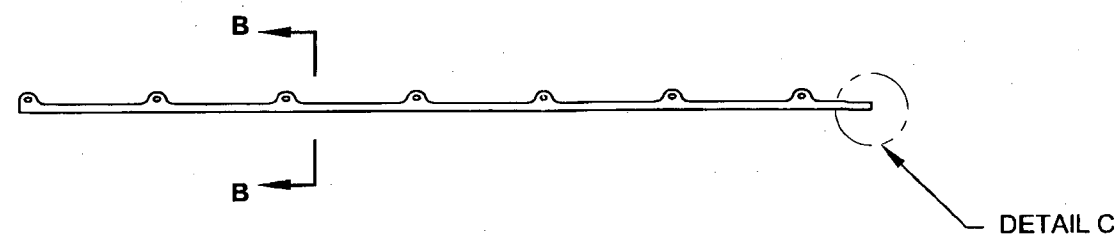
D3508-7F FLAT PATTERN



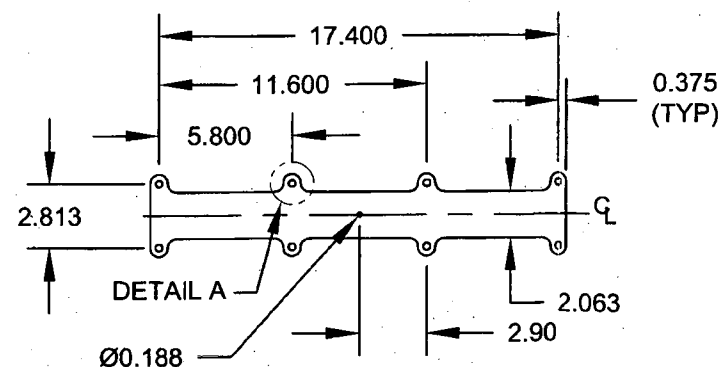
D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)



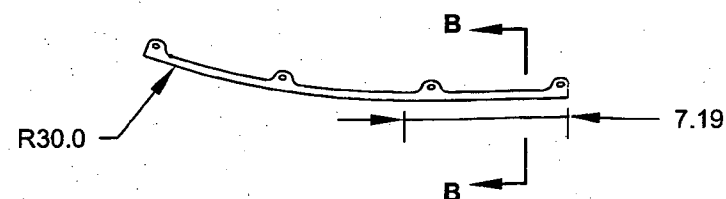
D3508-3 FLAT PATTERN



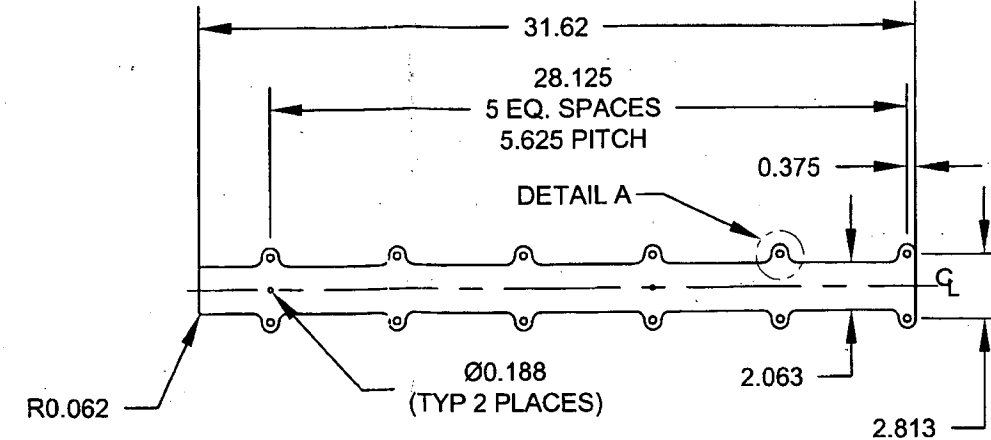
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



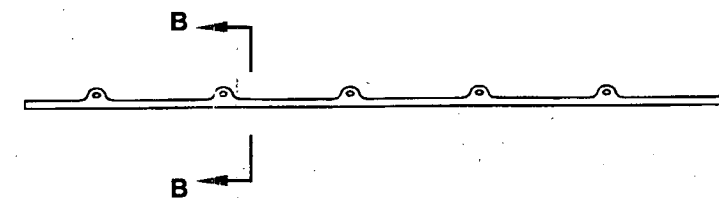
D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)



D3508-5 FLAT PATTERN



D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs, D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs, D3508-13 - 0.25 lbs

RELEASED
07-11-13
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40398

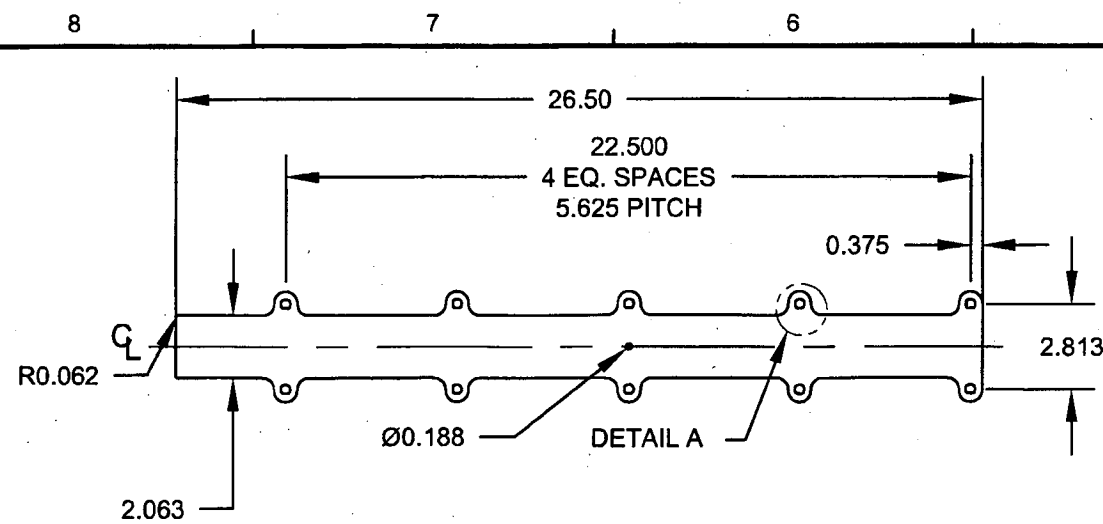
| | | | |
|------------|--------------------------------------------------------------------------------|----|----------|
| REV. | DESCRIPTION | BY | DATE |
| C | ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT | PH | 07.04.20 |
| B | CHANGE STAINLESS STEEL, WIDEN | PH | 06.10.27 |
| A | NEW ISSUE | PH | 06.04.21 |
| DESIGN | ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT | PH | 07.04.20 |
| DRAWN | ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT | PH | 07.04.20 |
| CHECKED | ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT | PH | 07.04.20 |
| MFG. APPR. | ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT | PH | 07.04.20 |
| APPROVED | ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT | PH | 07.04.20 |
| DE APPR. | ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT | PH | 07.04.20 |
| DATE | 07.04.20 | | |

DART AEROSPACE USA, INC
PORT HADLOCK, WA

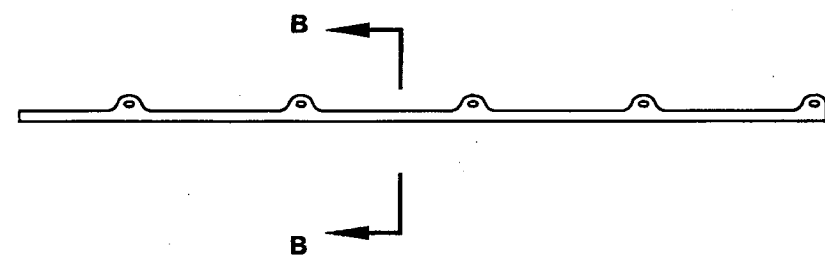
DRAWING NO. REV. C
D3508 SHEET 1 OF 2

TITLE SCALE
WEARPLATE 1:8

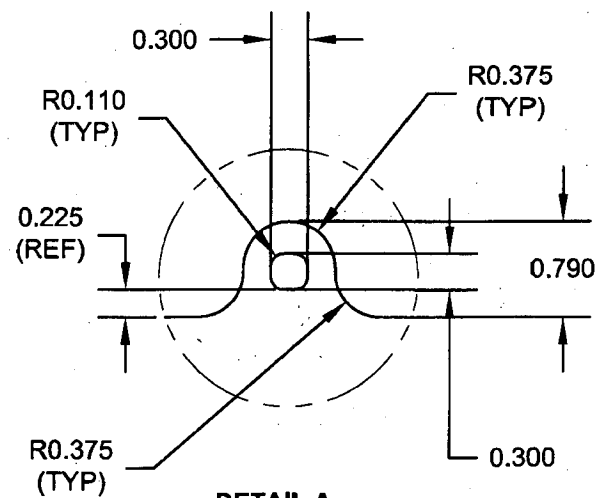
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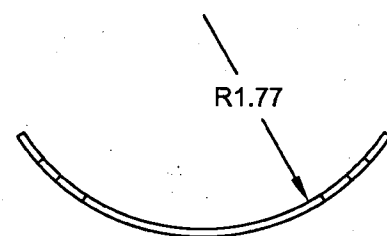
D3508-11F FLAT PATTERN



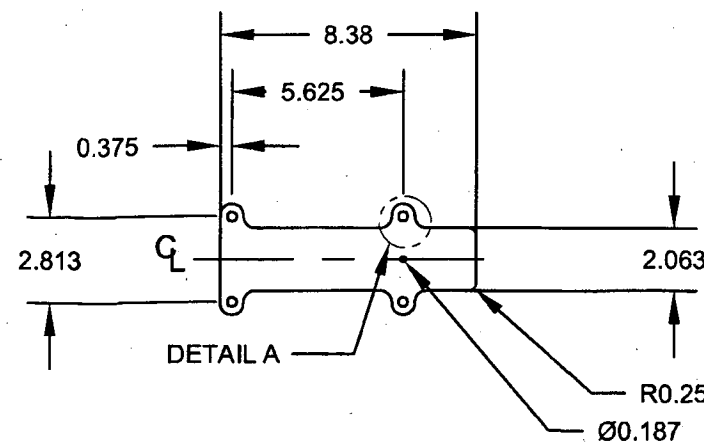
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



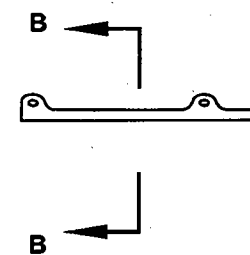
DETAIL A
(SCALE 2:3)



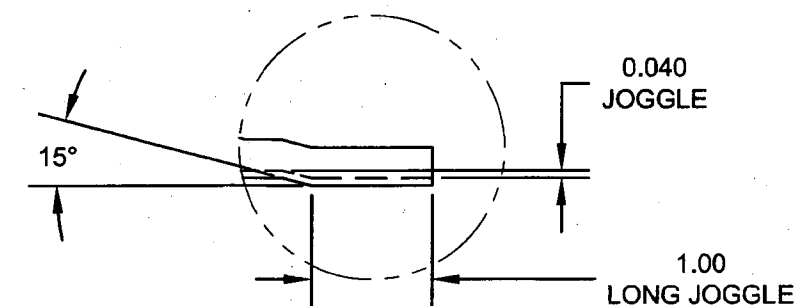
SECTION B-B
(SCALE 2:3)



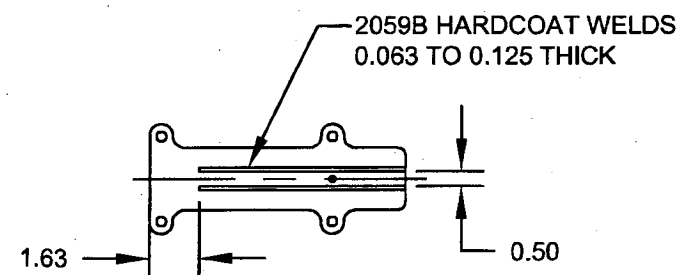
D3508-13F FLAT PATTERN



D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



DETAIL C
(SCALE 1:2)



D3508-13 WELDING DETAIL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40398

RELEASED
07-11-16

| | | | |
|------------|----------|------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN | PH | DART AEROSPACE USA, INC | |
| DRAWN | PH | PORT HADLOCK, WA | |
| CHECKED | PH | DRAWING NO. | REV. C |
| MFG. APPR. | PH | D3508 | SHEET 2 OF 2 |
| APPROVED | PH | TITLE | SCALE |
| DE APPR. | PH | WEARPLATE | 1:6 |
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